

# Work Order ID 69641

Friday, May 13, 2011 10:22:45 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: *11-05-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: <i>115928</i>								
	***PLEASE NOTE*** IF MAKING -041A OR -043A : DRILL HOLES FOR GAS SPRING IN D3825-041 AS PER DSI 9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

*Handwritten signature* 11.06.27

*Handwritten signature* 11.06.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8 4/06/28

Memo

0.00



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

IX 8 M-L 4/06/28

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 3:30

OVEN TEMPERATURE: 400 °F

FINISH TIME: 4:05

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

IX ~~Ø~~ M/L 11/06/28

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d M 11/06/29

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Identify as per dwg &amp; Stock Location:

6-A

0.00

Packaging

Memo

w/o

0.00

Packaging

69766

EP 11/06/29 @

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/06/29 JD

MF

11-06-29

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# Picklist Print

Friday, May 13, 2011 10:22:53 AM

Page 1

Work Order ID: 69641

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/13/2011


Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1		Manufactured	No			100	Each	22.0000	1	1			
													
Rib													

Location	Loc Qty	Loc Code
WA	12	
69261	12	
WA006	10	
67465	10	


B67465 (x1)

Pl 11.06.27

D2221-5		Manufactured	No			100	Each	8.0000	2	2			
													
Rib													

Location	Loc Qty	Loc Code
WA006	8	
67117	2	
67399	6	

Pl 11.06.27

D2221-7		Manufactured	No			100	Each	4.0000	1	1			
													
Rib													

Location	Loc Qty	Loc Code
WA006	4	
67274	4	

Pl 11.04.27

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100 Each

16.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA005

16

69211

16

D2235-1

Manufactured No

100 Each

16.0000

2

2



Basket Rib

Location

Loc Qty

Loc Code

WA

10

68606

10

WA005

6

66895

6

D2581

Manufactured No

100 Each

36.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

36

68964

36

D3442-1

Manufactured No

100 Each

11.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA005

11

64271

2

65783

9

D3825-041

Manufactured No

100 Each

0.0000

2

2



Rib Assembly (Basket End)

B69984

(x2)

6/11/06/27

Friday, May 13, 2011 10:22:53 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: 350 Basket Base

Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3826-041

Manufactured No

100

Each

0.0000

2

2



Rib / Gusset Assembly

D3827-041

Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA006

3

67275

3

D3832-1

Manufactured No

100

Each

2.0000

1

1



Mesh (Base)

Location

Loc Qty

Loc Code

WA

2

67477

2

D3833-1

Manufactured No

100

Each

13.0000

2

2



Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

13

65937

4

67459

9

B67464 (X2) PL11.06.27

PL11.06.27

B69114 (X1)

PL11.06.27

B69173

PL11.06.27

(2)

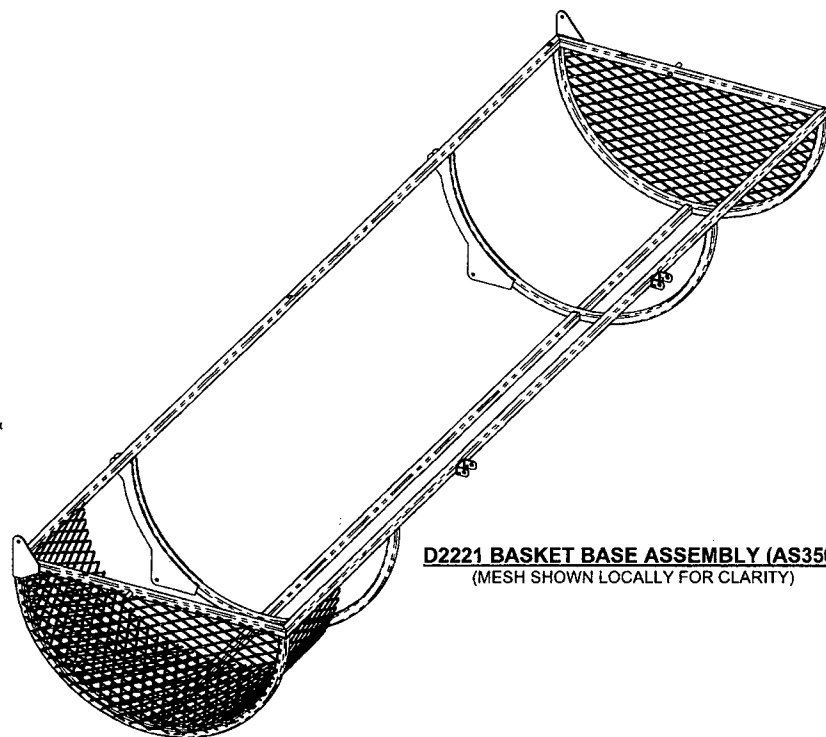
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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69641

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB ✓
3	2	D2221-5	RIB ✓
4	1	D2221-7	RIB ✓
5	2	D2232-3	BASKET HINGE ✓
6	2	D2235-1	RIB ✓
7	2	D2581	MOUNTING BRACKET ✓
8	2	D3442-1	SHIM ✓
9	2	D3825-041	RIB ASSY (BASKET END) ✓
10	2	D3826-041	RIB/GUSSET ASSY ✓
11	1	D3827-041	RIB ASSY (INBOARD) ✓
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-11/51-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

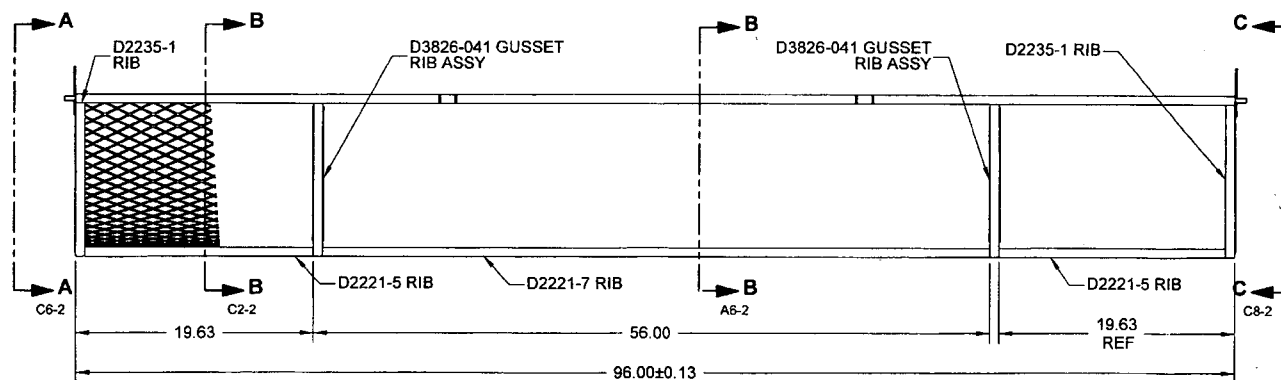
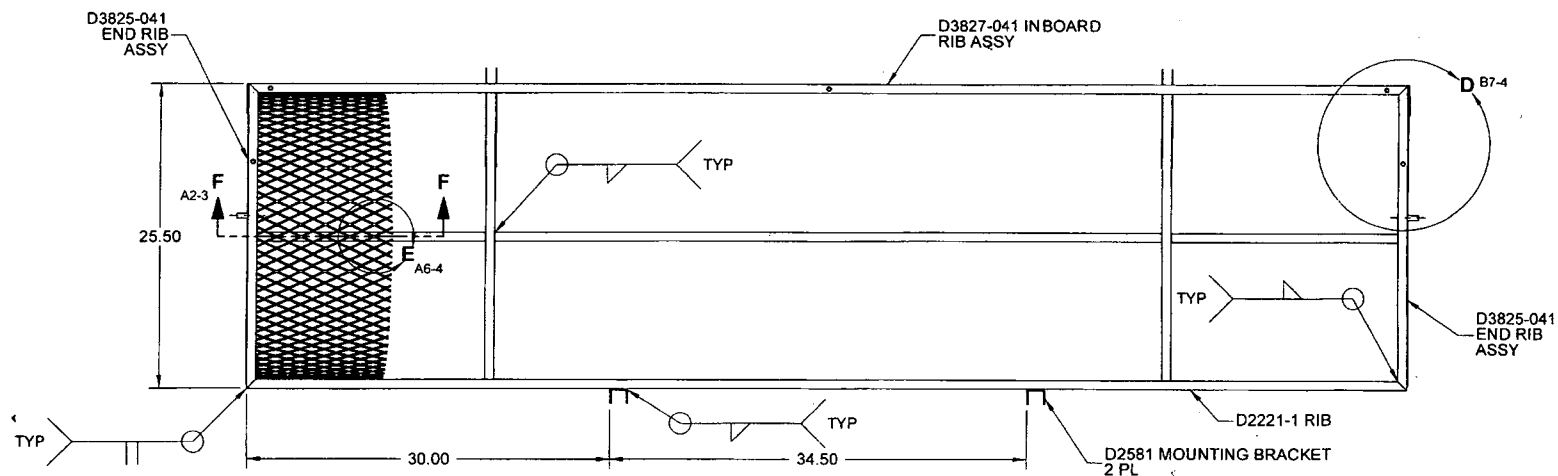
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18

DESIGN	B/W	<b>DART AEROSPACE LTD</b> ..	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b> NTS	
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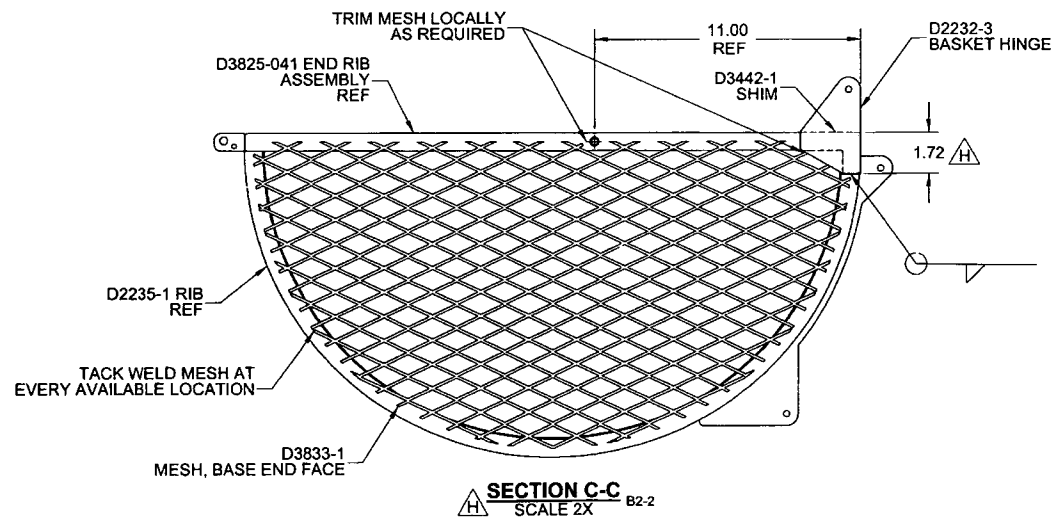
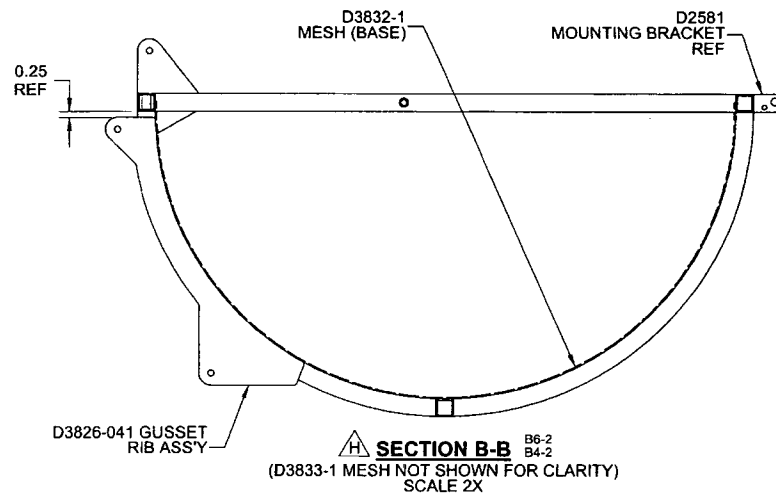
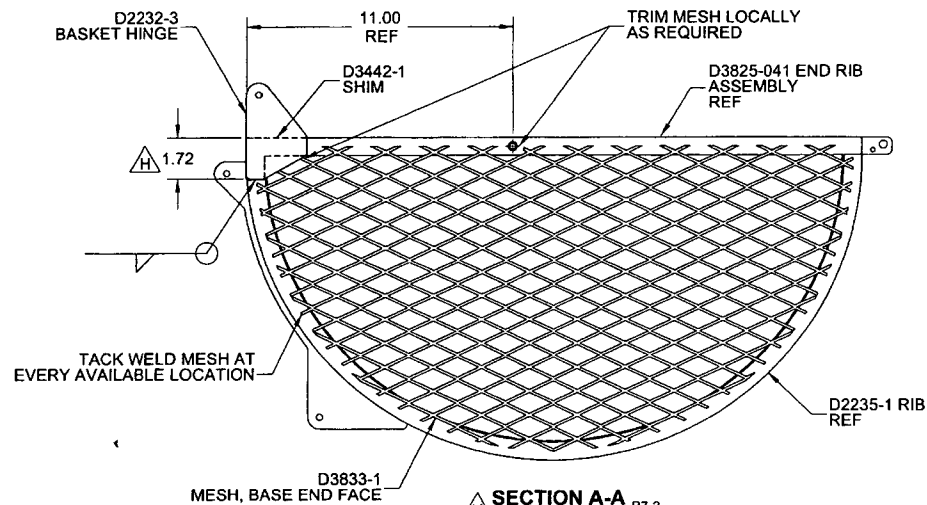
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*who away*

**RELEASE**  
08/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	SS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. H
MFG. APPR.	SS	D2221	SHEET 3 OF 3
APPROVED	MS	TITLE	SCALE
DE APPR.	SS	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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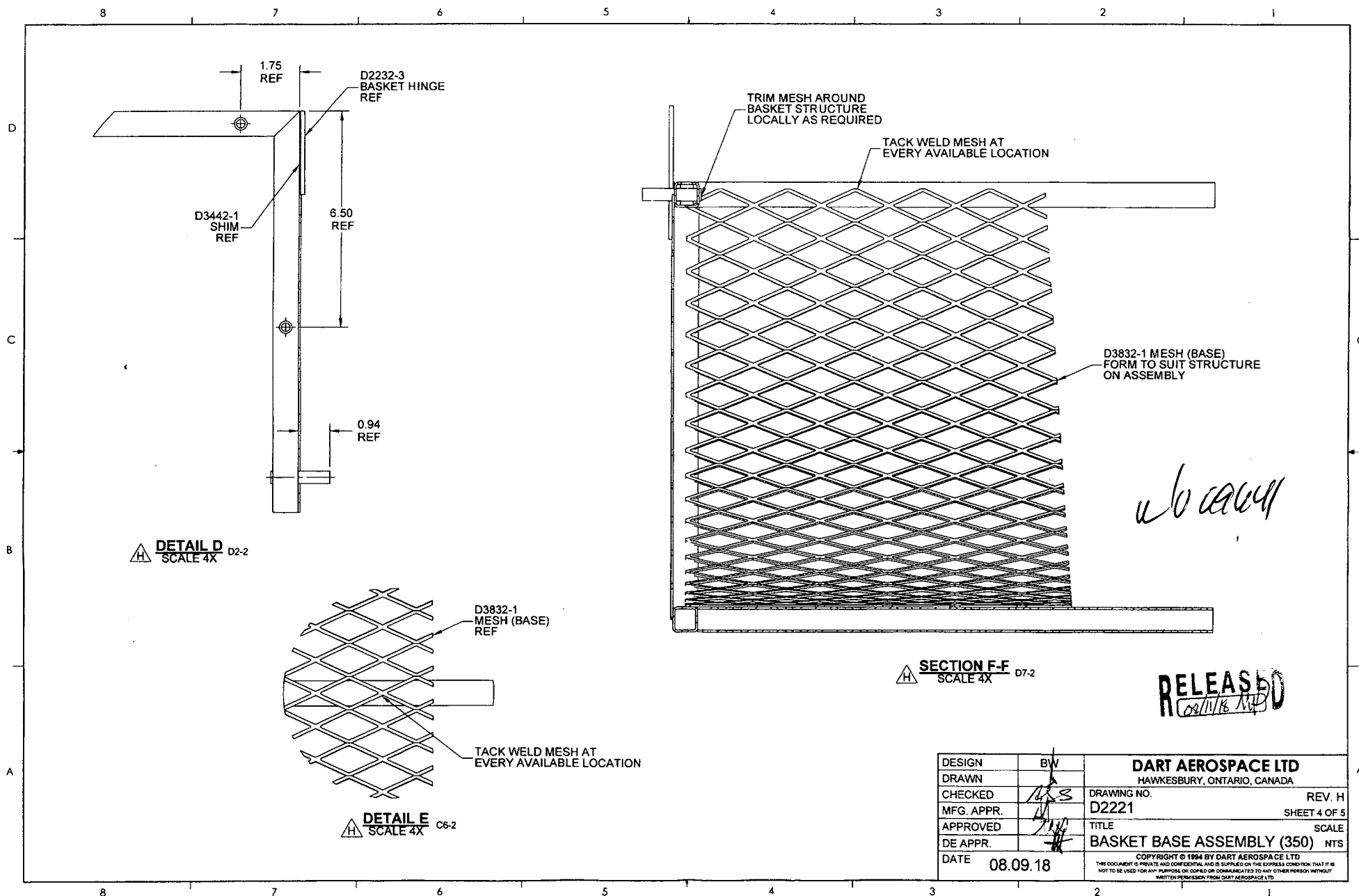
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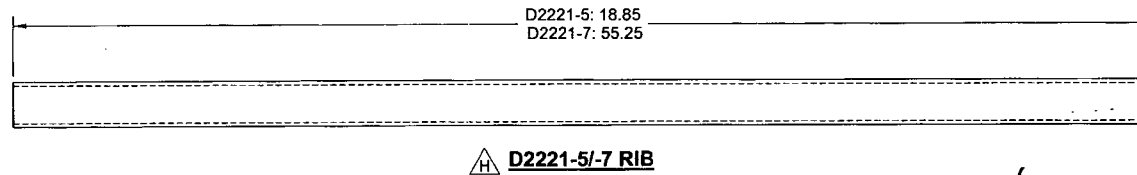
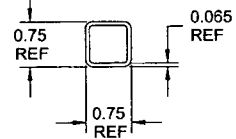
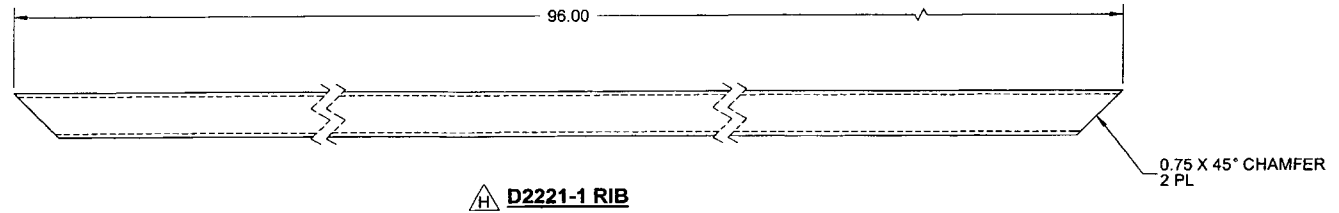
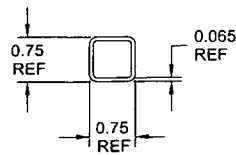
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*W/O 6964*

**RELEASED**  
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries